



Dart Aerospace Ltd.
1270 Aberdeen St
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D3121-25

Job Sheet 205987



Part No: D3121-25

Job Qty: 40 pcs

DAS

21

3-30

Part Name: Delrin Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/20

Job Tracking No:

Due Date: 2/13/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 06-05-10 JLM IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	40 pcs	2/13/20	2/13/20	0.50	0.53	Hardinge - 1		BM 20-01-23
120	QC 8	40 pcs	2/13/20	2/13/20	0.00	0.00	QC 8 - 12		OK 20/01/24
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Packaging 3-1 - Stock - B4B	40 pcs	2/13/20	2/13/20	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



Container No: S250187



Part: D3121-25

Job No: 205987

Serial No/Batch: S250187

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/23/20

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				Packaging 3 - 4 - B4B	51018	
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
140 QC 21 - SA				40 pcs	2/13/20	0.00 0.00
				QC 21 - SA - 21		
				QC 21 - SA - 70		
				QC 21 - SA - 53		

Part Op 100 - Hardinge -1-Turn D3121-25 Cap as per Folio FA387
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release)

JAN 24 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRR1.000	Delrin Round Bar 1" Color: Black	1.2800 ft (.032 ea)	100-Hardinge - 1	5242803

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	MDELRR1.000	1	16	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.315inches $\pm$ 0.010	0.325 0.305	0.315	VERN PJ-05
2	Cap	1.000inches $\pm$ 0.010	1.010 0.990	0.995	MIC FL-01
3	Cap	0.838inches $\pm$ 0.002	0.840 0.836	0.838	VERN
4	Cap	0.063inches $\pm$ 0.010	0.073 0.053	0.063	G-AUGE
5	Cap	0.010inches $\pm$ 0.010	0.020 0.000	0.010	G-AUGE
6	Cap	0.230inches $\pm$ 0.001	0.231 0.229	0.230	VERN
7	Cap	0.865inches $\pm$ 0.001	0.866 0.864	0.865	VERN + MATH

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					